

937

49:47 AM

642-341

Replacement Skidtube

Accept

Setup Start

Stop

Start Date: 7/14/2011 Start Qty: 1.00

Required Date: 7/29/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2650

F

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

N/A 2/11/08/10.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1937

7:49:47 AM

6-642-341

Accept

Replacement Skidtube

Start: 7/14/2011 Start Qty: 1.00
Required Date: 7/29/2011 Req'd Qty: 1.00

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110
Skidtubes
Skidtubes

Skidtubes

Memo

- 1-Deburr Fwd edge of tube
- 2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650
- 3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.
A/R: Aluminum Rod 1112860/M 115778
- 4-Grind weld flush to cap on top surface only.
- 5-Cut aft end to length as per dwg D2650
- 6-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. Open to Ø.312"
- 7-Drill holes for wearplates using DT-8028-5. Open to Ø 0.297".
- 8-Open Aft Cap Hole using #6 Drill Bit
- 9-Open holes for Tow Ring to Ø.625" as per Dwg D2650, D2650-5 Drilling Detail
- 10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650
- 11-Deburr and Blow out all chips from inside the tube

3 DL 11/02/14

BE 11/07/14

BE 11/07/14

DL 11/07/14

W/O:		WORK ORDER CHANGES					
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Work Order ID 71937

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Page 3

Item ID: D206-642-341

Revision ID:

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Start Date: 7/14/2011 Start Qty: 1.00

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Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

115



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

120



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

125



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00



BE 11/9/19

1 8 BE 11/9/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 71937

Thursday, July 14, 2011 7:49:47 AM



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Item ID: D206-642-341

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 7/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: Tooling:

Date:

Stop



QC:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)
2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)
3-Deburr. Blow out chips: Grind alodine off around crossbolt spacer.
4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting
Start Date: 11/07/20 Time: 10:15am
Finish Date: 11/07/22 Time: 4:00
A/R: Sikaflex-291 117516
Sikaflex expiry date: 12/01/20

DL 11/07/20

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

BE 11/07/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 71937

Thursday, July 14, 2011 7:49:47 AM

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Item ID: D206-642-341

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/RE: Aluminum Rod: *M112060 BE 11/07/12*

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

4- Install nut plate as per dwg

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

11.07.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 71937

Thursday, July 14, 2011 7:49:47 AM

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Item ID: D206-642-341

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Start Date: 7/14/2011 Start Qty: 1.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

190

Pressure Wash per QSI005 4.3

0.00

HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

205

0.00

SprayPaint

Memo

0.00

Spray Painting

PRIME B 117313
PAINT DELFLEET BLUE B 118325
CLEAR DELFLEET B 118053

11 07 26 (1)

1 6 11 07 26

RT 11-08-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 71937

Thursday, July 14, 2011 7:49:47 AM

Page 7

Item ID: D206-642-341

Accept

Revision ID:

Item Name: Replacement Skidtube

Start Date: 7/14/2011 Start Qty: 1.00

Required Date: 7/29/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

215

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

① 11-08-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 71937

Thursday, July 14, 2011 7:49:47 AM

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Item ID: D206-642-341

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 7/14/2011 Start Qty: 1.00

Required Date: 7/29/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start

QC: Date:

SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate

A/R ☐ Sikaflex-291 ☐Sikaflex expiry date: ☐

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with Sikaflex Clean excess adhesive

A/R ☐ Sikaflex-291 ☐Sikaflex expiry date: ☐

6-Wing Walk as per Dwg D2650.5 and QSI 005 4.4

Batch:

X Ø M-L 11/08/08

M 116040
11/08M 116040
11/08

M 118313

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 71937

Thursday, July 14, 2011 7:49:47 AM



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Item ID: D206-642-341

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 7/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

IX & m-f 11/08/08

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulston

(tl)

250

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-341

Location: _____

PPP Rev: _____

PPP

70937

Paul/S

Work Order ID 71937

Thursday, July 14, 2011 7:49:47 AM

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Item ID: D206-642-341

Accept

Revision ID:

Item Name: Replacement Skidtube

Start Date: 7/14/2011 Start Qty: 1.00

Required Date: 7/29/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 4/08/10

11-08-9

Picklist Print

Thursday, July 14, 2011 7:49:44 AM

Page 1

Work Order ID: 71937

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube



Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG0041 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS4-1032-130		Purchased	No			220	Each	2,518.000	54	54			
---------------	--	-----------	----	--	--	-----	------	-----------	----	----	--	--	--



Insert

Location

Loc Qty

Loc Code

ST281

8

117331

8

ST282

2510

117717

510

118237

1744

118312

256

AN960C10L	NAS1149C0332 R	Purchased	No			220	Each	0.0000	54	54			
-----------	-------------------	-----------	----	--	--	-----	------	--------	----	----	--	--	--



washer

AN960JD10L	NAS1149D0332J	Purchased	No			220	Each	0.0000	2	2			
------------	---------------	-----------	----	--	--	-----	------	--------	---	---	--	--	--



Washer

AN960JD416	NAS1149D0463J	Purchased	No				Each	0.0000					
------------	---------------	-----------	----	--	--	--	------	--------	--	--	--	--	--



Washer

118386

54x

m-11/08/08

m 118306

54x m-11/08/08

m 117087

2x m-11/08/08

~~m 116805~~

1x m-11/08/08

m 118179

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, July 14, 2011 7:49:44 AM

Work Order ID: 71937

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Page 2

7.

Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

Each

519.0000

2



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

517

117086

59

117849

458

Each

1,198.000

2

CR3212-4-03

Purchased

No



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1196

114859

1196

Each

10.0000

1

D2620

Manufactured

No



Skidtube, 206 Skidtube

Location

Loc Qty

Loc Code

LG

10

68136

3

71616

7

Wh

11/07/25

Wh

11/07/25

Wh

11/07/14

Thursday, July 14, 2011 7:49:45 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 71937

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube



Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

220

Each

75.0000

1

1



Aft Cap



Location

Loc Qty

Loc Code

FP004

58

68280

58

FP006

5

62678

5

FP-4

1

70945

1

fp5

11

71038 ✓

11

D2647

Manufactured No

Each

47.0000

1



Cap



Location

Loc Qty

Loc Code

LG002

47

55352

17

71171

30

D2649

Manufactured No

Each

121.0000

19



Cross Bolt Spacer



Location

Loc Qty

Loc Code

LG

109

68224

2

71355

107

LG001

12

65317

1

68507

11

m-LU/08/08

BE-11/07/14

BE-11/07/22

19

Thursday, July 14, 2011 7:49:45 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Thursday, July 14, 2011 7:49:45 AM

Page 4

Work Order ID: 71937

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

D2651-1

Manufactured No

220

Each

429.0000

14

14



Plug

Location

Loc Qty

Loc Code

fpa	109
69018	109
FP-A	320
57869	1
66445	10
67760	50
70691	100
70827	2
70839	4
70942	52
71037	101

m-l 11/08/08

D2651-3

Manufactured No

220

Each

438.0000

14

14



O-Ring

Location

Loc Qty

Loc Code

FP-A	438
61962	26
66956	412

14x
m-l 11/08/08

D2654-5

Manufactured No

Each

0.0000



Web

D2680-041

Manufactured No

Each

23.0000



Nut Plate

Location

Loc Qty

Loc Code

ST020	23
55366	17
70088	6

14x
DL
11/07/20

DL
11/07/25

Thursday, July 14, 2011 7:49:45 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
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Work Order ID: 71937

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Page 5

7

Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-11

Manufactured No

220 Each

22.0000

1

1



Wearshoe



m-l 11/08/08

Location

Loc Qty

Loc Code

FP019

22

68362

1

70879

8

71284

13

IX

D3535-23

Manufactured No

220 Each

38.0000

1

1



Wearshoe



m-l 11/08/08

Location

Loc Qty

Loc Code

FP021

38

68342

10

70818

16

71581

12

IX

D3535-35

Manufactured No

220 Each

31.0000

1

1



Wearshoe



m-l 11/08/08

Location

Loc Qty

Loc Code

FP018

14

65926

1

67598

1

70815

12

ST

17

69756

17

IX

Thursday, July 14, 2011 7:49:45 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 14, 2011 7:49:45 AM

Work Order ID: 71937

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Page 6

7.

Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-11

Manufactured No

220

Each

19.0000

1

m-l 11/08/08



Gasket

Location

Loc Qty

Loc Code

FP011

19

46649

1

46715

4

65574

1

71283 ✓

13

D3536-23

Manufactured No

220

Each

39.0000

1

m-l 11/08/08



Gasket

Location

Loc Qty

Loc Code

FP011

39

43406

1

66560

1

69902 ✓

25

71579

12

D3536-35

Manufactured No

220

Each

31.0000

1

m-l 11/08/08



Gasket

Location

Loc Qty

Loc Code

FP012

31

69755 ✓

17

71587

14

D3537-1

Manufactured No

220

Each

34.0000

6

m-l 11/08/08



Wearpad

Location

Loc Qty

Loc Code

FP017

34

69817

5

70686

29

Thursday, July 14, 2011 7:49:45 AM

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71574 6x

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 14, 2011 7:49:45 AM

Work Order ID: 71937

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube



Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-3

 Manufactured No
 Wearpad

220 Each 6.0000 1 1



m-l 11/08/08

Location	Loc Qty	Loc Code
FP017	6	
35697	1	
70817	5	

76481

1X

MS27039-4-06

 Purchased No
 Screw

220 Each 50.0000 1 1



m-l 11/08/08

Location	Loc Qty	Loc Code
FP-A	16	
115460	16	
ST292	34	
115460	34	

1X

MS27039C1-08

 Purchased No
 SCREW

Each 1,292.000 56



m-l 11/08/08

Location	Loc Qty	Loc Code
FP-A	1	
116022	1	
ST293	1291	
116373	3	
117291	288	
118077	500	
118159	500	

56

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

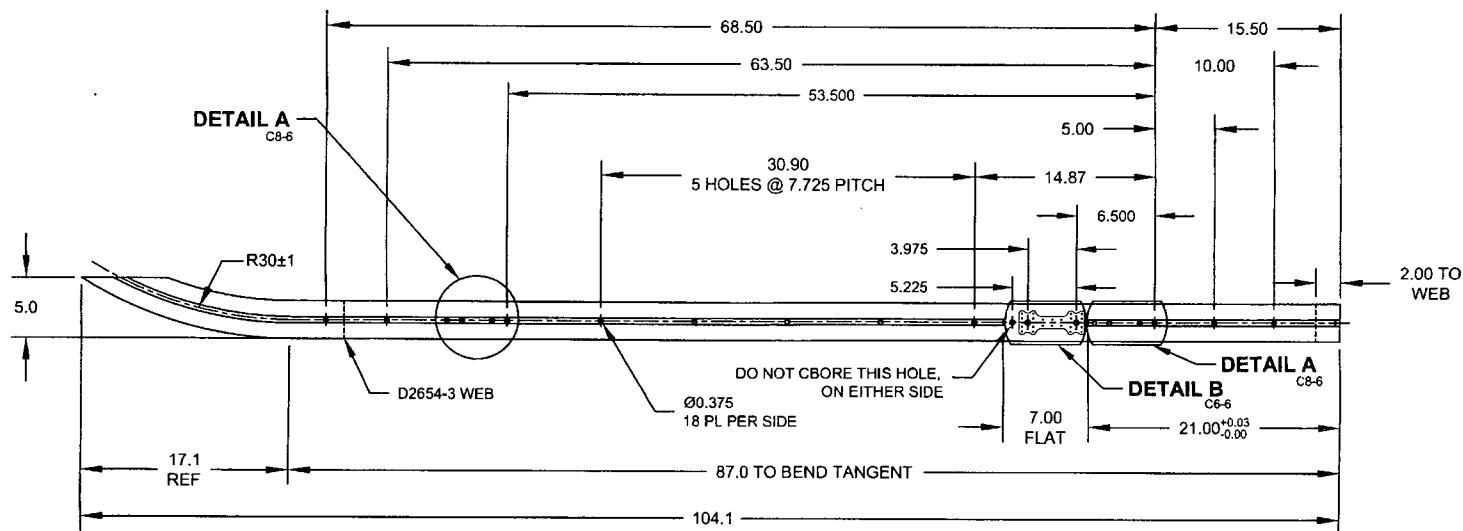
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

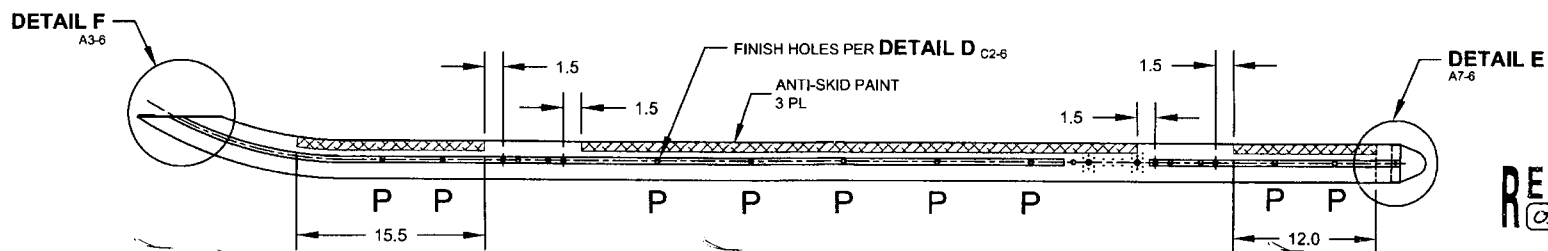
RELEASED
08-07-23/17

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	08.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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WLB
21937



D2650-3 BENDING/DRILLING DETAIL

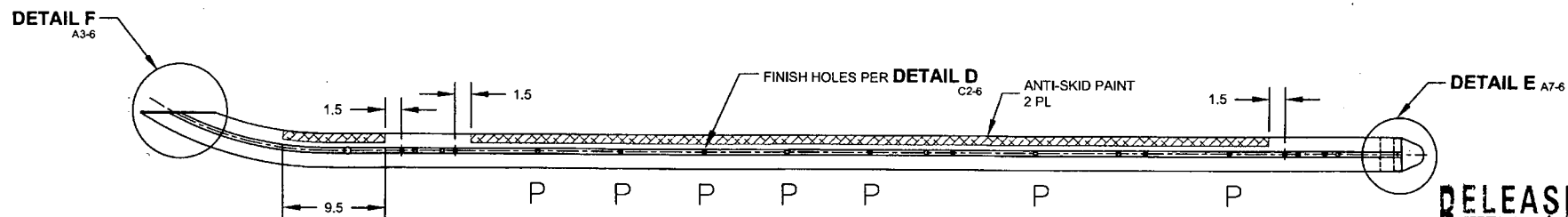
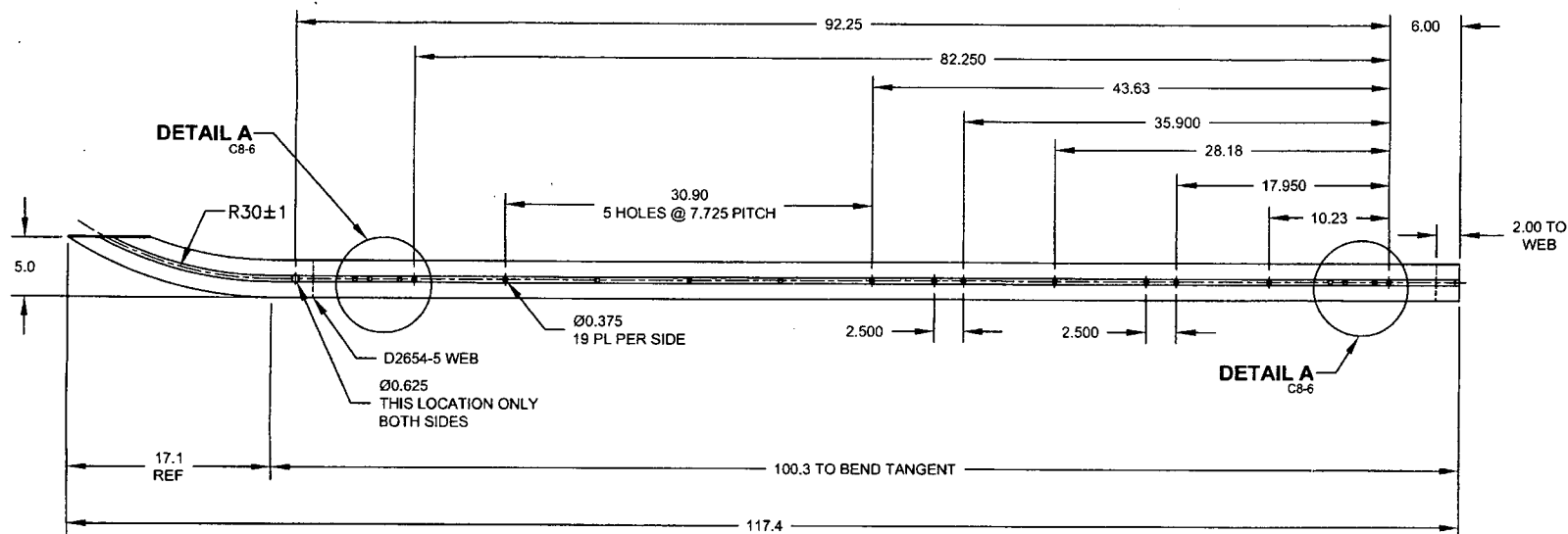


D2650-3 ASSEMBLY/FINISHING DETAIL

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08-07-22 110

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
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